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D3196-3**Job Sheet 191869****Part No:** D3196-3**Job Qty:** 6 pcs**Part Name:** Bar**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/11/19**Job Tracking No:****Due Date:** 4/10/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C IPP Rev: A New Issue 05-11-08 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	DAS		
100	Bandsaw - 1	6 pcs		4/10/19	0.00	0.01	Bandsaw - 1	52		19/05/27
110	HAAS 4 Axis - B4B	6 pcs		4/10/19	0.89	5.83	HAAS - 1 - B4B	52		19/05/27
							HAAS - 2 - B4B	9-89		
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	6 pcs		4/10/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51	52		
							QC 2 - 52	9-89		19/05/27
							QC 2 - 54			
							QC 2 - 56			



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Container No: S184074**Part:** D3196-3**Job No:** 191869**Serial No/Batch:** S184074**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 05/27/19

130 QC 8	6 pcs	4/10/19	0.00 0.00	QC 2 - 57		
				QC 2 - 62		
				QC 2 - 63		
				QC 2 - 8		
				QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 8 - 12		
				QC 8 - 14	m/19/05/27	
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
140 Handfinish - 1-1 Chemical- B4B	6 pcs	4/10/19	0.00 0.46	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B	MAY 27 2019	
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 -		
				Plex 3/11/19 11:01 AM Dart.lajeunesse.marie		

				B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	6 pcs	4/10/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	6 pcs	4/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
170 Packaging 3-1 - Stock - B4B	6 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
180 QC 21 - SA	6 pcs	4/10/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blank: (0.75" x 1.50") x 34.750" long Bar Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3196-3 as per Folio FA339 and Dwg D3196Identify as D3196-3 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check)					

- 140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	17.3400 ft (2.89 ea)	100-Bandsaw - 1	568972

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	17	41	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bar	34.625inches $\pm$ 0.010	34.635 34.615	34.625	
2	Bar	33.650inches $\pm$ 0.005	33.655 33.645	33.649	
3	Bar	0.488inches $\pm$ 0.005	0.493 0.483	0.488	
4	Bar	17.011inches $\pm$ 0.010	17.021 17.001	17.012	
5	Bar	0.512inches $\pm$ 0.005	0.517 0.507	0.512	
6	Bar	1.500inches $\pm$ 0.010	1.510 1.490	1.502	
7	Bar	0.464inches $\pm$ 0.010	0.474 0.454	0.464	
8	Bar	0.504inches $\pm$ 0.010	0.514 0.494	0.504	
9	Bar	0.344inches $\pm$ 0.006 - 0.001	0.350 0.343	0.345	Diameter
10	Bar	0.660inches $\pm$ 0.008 - 0.001	0.668 0.659	0.663	Diameter
11	Bar	100.000Degrees $\pm$ 0.500	100.500 99.500	100°	
12	Bar	0.962inches $\pm$ 0.005	0.967 0.957	0.962	
13	Bar	0.750inches $\pm$ 0.010	0.760 0.740	0.750	
14	Bar	4.750inches $\pm$ 0.010	4.760 4.740	4.752	
15	Bar	12.531inches $\pm$ 0.010	12.541 12.521	12.533	
16	Bar	16.999inches $\pm$ 0.010	17.009 16.989	17.007	
17	Bar	21.844inches $\pm$ 0.010	21.854 21.834	21.846	
18	Bar	29.625inches $\pm$ 0.010	29.635 29.615	29.627	
19	Bar	0.250inches $\pm$ 0.010	0.260 0.240	0.250	
20	Bar	1.000inches $\pm$ 0.010	1.010 0.990	1.000	
21	Bar	0.125inches $\pm$ 0.010	0.135 0.115	0.125	Radius
22	Bar	0.987inches $\pm$ 0.010	0.997 0.977	0.991	
23	Bar	0.060inches $\pm$ 0.010	0.070 0.050	0.06	
24	Bar	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							